This manual provides critical safety instructions on the proper setup, operation, maintenance, and service of this machine/tool. Save this document, refer to it often, and use it to instruct other operators.

Failure to read, understand and follow the instructions in this manual may result in fire or serious personal injury—including amputation, electrocution, or death.

The owner of this machine/tool is solely responsible for its safe use. This responsibility includes but is not limited to proper installation in a safe environment, personnel training and usage authorization, proper inspection and maintenance, manual availability and comprehension, application of safety devices, cutting/sanding/grinding tool integrity, and the usage of personal protective equipment.

The manufacturer will not be held liable for injury or property damage from negligence, improper training, machine modifications or misuse.

Some dust created by power sanding, sawing, grinding, drilling, and other construction activities contains chemicals known to the State of California to cause cancer, birth defects or other reproductive harm. Some examples of these chemicals are:

- Lead from lead-based paints.
- Crystalline silica from bricks, cement and other masonry products.
- Arsenic and chromium from chemically-treated lumber.

Your risk from these exposures varies, depending on how often you do this type of work. To reduce your exposure to these chemicals: Work in a well ventilated area, and work with approved safety equipment, such as those dust masks that are specially designed to filter out microscopic particles.
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INTRODUCTION

Machine Description

The Model G0563/G0564 Oscillating Edge Sander features an oscillating belt and spindle drum, two dust ports, a T-Slot and miter gauge, and a quick release tension lever. Vertical adjustment of the edge-sanding table is handwheel-controlled, and the sanding belt tilts from 0 to 90 degrees.

Both models are equipped with a 240V, single-phase motor. Model G0563 comes with a 2 HP, 9A motor, and Model G0564 is powered by a 3 HP, 9A motor.

Contact Info

We stand behind our machines! If you have questions or need help, contact us with the information below. Before contacting, make sure you get the serial number and manufacture date from the machine ID label. This will help us help you faster.

Grizzly Technical Support
1815 W. Battlefield
Springfield, MO 65807
Phone: (570) 546-9663
Email: techsupport@grizzly.com

We want your feedback on this manual. What did you like about it? Where could it be improved? Please take a few minutes to give us feedback.

Grizzly Documentation Manager
P.O. Box 2069
Bellingham, WA 98227-2069
Email: manuals@grizzly.com

Manual Accuracy

We are proud to provide a high-quality owner’s manual with your new machine!

We made every effort to be exact with the instructions, specifications, drawings, and photographs in this manual. Sometimes we make mistakes, but our policy of continuous improvement also means that sometimes the machine you receive is slightly different than shown in the manual.

If you find this to be the case, and the difference between the manual and machine leaves you confused or unsure about something, check our website for an updated version. We post current manuals and manual updates for free on our website at www.grizzly.com.

Alternatively, you can call our Technical Support for help. Before calling, make sure you write down the Manufacture Date and Serial Number from the machine ID label (see below). This information is required for us to provide proper tech support, and it helps us determine if updated documentation is available for your machine.

<table>
<thead>
<tr>
<th>Model GXXXX</th>
<th>MACHINE NAME</th>
</tr>
</thead>
<tbody>
<tr>
<td>SPECIFICATIONS</td>
<td>WARNING!</td>
</tr>
<tr>
<td>Motor: Specification:</td>
<td>To reduce risk of serious injury when using this machine:</td>
</tr>
<tr>
<td>Specification:</td>
<td>1. Read and understand the manual before operation.</td>
</tr>
<tr>
<td>Specification:</td>
<td>2. Only operate with the guard in place.</td>
</tr>
<tr>
<td>Specification:</td>
<td>3. Maintain all guards and interlocks in good working order.</td>
</tr>
<tr>
<td>Weight:</td>
<td>4. Make sure the motor has stopped and disconnect power before adjustments, maintenance, or service.</td>
</tr>
<tr>
<td>Manufacture Date:</td>
<td>5. DO NOT expose to rain or dampness.</td>
</tr>
<tr>
<td>Serial Number:</td>
<td>6. DO NOT modify this machine in any way.</td>
</tr>
<tr>
<td>Manufacture Date:</td>
<td>7.</td>
</tr>
<tr>
<td>Serial Number:</td>
<td>8.</td>
</tr>
<tr>
<td>Manufacture Date:</td>
<td>9.</td>
</tr>
<tr>
<td>Serial Number:</td>
<td>10.</td>
</tr>
<tr>
<td>Manufacture Date:</td>
<td>Maintain machine carefully to prevent accidents.</td>
</tr>
<tr>
<td>Serial Number:</td>
<td></td>
</tr>
<tr>
<td>Manufacture Date:</td>
<td></td>
</tr>
<tr>
<td>Serial Number:</td>
<td></td>
</tr>
<tr>
<td>Manufacture Date:</td>
<td></td>
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<tr>
<td>Serial Number:</td>
<td></td>
</tr>
<tr>
<td>Manufacture Date:</td>
<td></td>
</tr>
<tr>
<td>Serial Number:</td>
<td></td>
</tr>
</tbody>
</table>

We want your feedback on this manual. What did you like about it? Where could it be improved? Please take a few minutes to give us feedback.

Grizzly Documentation Manager
P.O. Box 2069
Bellingham, WA 98227-2069
Email: manuals@grizzly.com
MODEL G0563 OSCILLATING EDGE SANDER 2 HP

Product Dimensions:
- Weight: 396 lbs.
- Width (side-to-side) x Depth (front-to-back) x Height: 50-1/2 x 23 x 49 in.
- Footprint (Length x Width): 22-1/2 x 19-1/2 in.

Shipping Dimensions:
- Type: Wood Crate
- Content: Machine
- Weight: 504 lbs.
- Length x Width x Height: 48 x 30 x 44 in.
- Must Ship Upright: Yes

Electrical:
- Power Requirement: 240V, Single-Phase, 60 Hz
- Prewired Voltage: 240V
- Full-Load Current Rating: 9A
- Minimum Circuit Size: 15A
- Connection Type: Cord & Plug
- Power Cord Included: Yes
- Power Cord Length: 10 ft.
- Power Cord Gauge: 14 AWG
- Plug Included: No
- Recommended Plug Type: 6-15
- Switch Type: Magnetic Switch w/Overload Protection

Motors:
- Main
  - Type: TEFC Capacitor-Start Induction
  - Horsepower: 2 HP
  - Phase: Single-Phase
  - Amps: 9A
  - Speed: 1725 RPM
  - Power Transfer: Direct Drive
  - Bearings: Shielded & Permanently Lubricated

Main Specifications:

Operation Information
- Sanding Belt Speed: 3150 FPM
- Sanding Belt Oscillations: 1/4 in.
- Sanding Belt Length: 89 in.
- Sanding Belt Width: 6 in.
- Sanding Belt Tilt: 0 – 90 deg.
Table Information

<table>
<thead>
<tr>
<th>Specification</th>
<th>Measurement</th>
</tr>
</thead>
<tbody>
<tr>
<td>Table Length</td>
<td>26-7/8 in.</td>
</tr>
<tr>
<td>Table Width</td>
<td>12 in.</td>
</tr>
<tr>
<td>Table Thickness</td>
<td>1-1/4 in.</td>
</tr>
<tr>
<td>Table Travel</td>
<td>3-3/4 in.</td>
</tr>
<tr>
<td>Floor To Table Height</td>
<td>35-3/4 – 39-1/2 in.</td>
</tr>
<tr>
<td>End Table Length</td>
<td>11-1/2 in.</td>
</tr>
<tr>
<td>End Table Width</td>
<td>10 in.</td>
</tr>
<tr>
<td>End Table Thickness</td>
<td>3/4 in.</td>
</tr>
<tr>
<td>End Table Travel</td>
<td>10 in.</td>
</tr>
</tbody>
</table>

Platen Information

<table>
<thead>
<tr>
<th>Specification</th>
<th>Measurement</th>
</tr>
</thead>
<tbody>
<tr>
<td>Platen Type</td>
<td>Graphite Coated</td>
</tr>
<tr>
<td>Platen Length</td>
<td>30-1/4 in.</td>
</tr>
<tr>
<td>Platen Width</td>
<td>6-3/4 in.</td>
</tr>
</tbody>
</table>

Construction

<table>
<thead>
<tr>
<th>Component</th>
<th>Material</th>
</tr>
</thead>
<tbody>
<tr>
<td>Table</td>
<td>Precision-Ground Cast Iron</td>
</tr>
<tr>
<td>Frame</td>
<td>Steel</td>
</tr>
<tr>
<td>Base</td>
<td>Steel</td>
</tr>
<tr>
<td>Drive Roller</td>
<td>Aluminum</td>
</tr>
<tr>
<td>Idler Roller</td>
<td>Rubber</td>
</tr>
<tr>
<td>Paint Type/Finish</td>
<td>Powder Coated</td>
</tr>
</tbody>
</table>

Other Related Information

<table>
<thead>
<tr>
<th>Specification</th>
<th>Measurement</th>
</tr>
</thead>
<tbody>
<tr>
<td>Number of Dust Ports</td>
<td>2</td>
</tr>
<tr>
<td>Dust Port Size</td>
<td>4 in.</td>
</tr>
<tr>
<td>Belt Release</td>
<td>Quick Release</td>
</tr>
<tr>
<td>Drive Roller Size</td>
<td>7 in.</td>
</tr>
<tr>
<td>Idler Roller Size</td>
<td>3-7/8 in.</td>
</tr>
</tbody>
</table>

Other Specifications:

<table>
<thead>
<tr>
<th>Specification</th>
<th>Measurement</th>
</tr>
</thead>
<tbody>
<tr>
<td>Country of Origin</td>
<td>Taiwan</td>
</tr>
<tr>
<td>Warranty</td>
<td>1 Year</td>
</tr>
<tr>
<td>Approximate Assembly &amp; Setup Time</td>
<td>15 Minutes</td>
</tr>
<tr>
<td>Serial Number Location</td>
<td>ID Label on Base</td>
</tr>
<tr>
<td>Sound Rating</td>
<td>90 dB</td>
</tr>
<tr>
<td>ISO 9001 Factory</td>
<td>No</td>
</tr>
<tr>
<td>Certified by a Nationally Recognized Testing Laboratory (NRTL)</td>
<td>Yes</td>
</tr>
</tbody>
</table>

Features:

- Sanding Surface Tilts Vertical to Horizontal
- T-Slot Table and Miter Gauge
- Quick Release Belt Tension Lever
- Graphite Coated Platen
- Oscillating Sanding Surfaces
- Sanding Belt Oscillates at 52 Cycles per Minute
- Includes 3 Spindles Drums: 1 1/2", 2", 3" x 4 1/2"
- Platen Tilts 0 to 90 degrees (5 deg. Scale)
MODEL G0564 OSCILLATING EDGE SANDER 3 HP

Product Dimensions:
- Weight: 495 lbs.
- Width (side-to-side) x Depth (front-to-back) x Height: 60 x 28 x 49 in.
- Footprint (Length x Width): 32 x 19-1/2 in.

Shipping Dimensions:
- Type: Wood Crate
- Content: Machine
- Weight: 597 lbs.
- Length x Width x Height: 58 x 30 x 44 in.
- Must Ship Upright: Yes

Electrical:
- Power Requirement: 240V, Single-Phase, 60 Hz
- Prewired Voltage: 240V
- Full-Load Current Rating: 11A
- Minimum Circuit Size: 15A
- Connection Type: Cord & Plug
- Power Cord Included: Yes
- Power Cord Length: 10 ft.
- Power Cord Gauge: 12 AWG
- Plug Included: Yes
- Included Plug Type: NEMA 6-15
- Switch Type: Magnetic Switch w/Overload Protection

Motors:
- Type: TEFC Capacitor-Start Induction
- Horsepower: 3 HP
- Phase: Single-Phase
- Amps: 11A
- Speed: 1725 RPM
- Power Transfer: Direct Drive
- Bearings: Shielded & Permanently Lubricated

Main Specifications:

Operation Information
- Sanding Belt Speed: 3150 FPM
- Sanding Belt Oscillations: 1/4 in.
- Sanding Belt Length: 108 in.
- Sanding Belt Width: 6 in.
- Sanding Belt Tilt: 0 – 90 deg.
Table Information

Table Length: 35-1/2 in.
Table Width: 12 in.
Table Thickness: 1-1/2 in.
Table Travel: 4 in.
Floor To Table Height: 35-3/4 – 39-3/4 in.
End Table Length: 11-1/2 in.
End Table Width: 10 in.
End Table Thickness: 3/4 in.
End Table Travel: 10 in.

Platen Information

Platen Type: Graphite Coated
Platen Width: 6-3/4 in.

Construction

Table: Precision Ground Cast Iron
Frame: Steel
Base: Steel
Drive Roller: Aluminum
Idler Roller: Rubber
Miter Block: Aluminum
Paint Type/Finish: Powder Coated

Other Related Information

Number of Dust Ports: 2
Dust Port Size: 4 in.
Belt Release: Quick Release
Drive Roller Size: 7 in.
Idler Roller Size: 3-7/8 in.

Other Specifications:

Country of Origin: Taiwan
Warranty: 1 Year
Approximate Assembly & Setup Time: 15 Minutes
Serial Number Location: ID Label on Base
Sound Rating: 90 dB
ISO 9001 Factory: No
Certified by a Nationally Recognized Testing Laboratory (NRTL): Yes

Features:

Sanding Surfaces Tilts Vertical and Horizontal
T-Slot Table and Miter Gauge
Quick Belt Release Lever
Graphite Coated Platen
Oscillating Sanding Surfaces
Sanding Belt Oscillates at 52 Cycles per Minute
Includes 3 Sanding Drums: 1 1/2", 2", 3" x 4 1/2"
Platen Tilts 0 to 90 degrees (5 deg. Scale)
Machine Features

Figure 1. Main features of the G0563/G0564.

A. Sanding Spindle Table  
B. Sanding Spindle  
C. Belt Access Door  
D. Emergency Stop Switch  
E. Back Stop  
F. Rear Dust Port  
G. Motor  
H. Angle Adjustment & Lock Handle  
I. Belt Tracking Adjustment  
J. Table Lock Levers  
K. Vertical Adjustment Handwheel  
L. Storage Compartment  
M. Sanding Table  
N. ON/OFF Switch  
O. Vertical Adjustment Lock Handles  
P. Spindle Table Adjustment Lock Handle

⚠️ WARNING ⚠️

For Your Own Safety Read This Manual Before Operating Sander

a) Wear eye protection.  
b) Support workpiece on worktable.  
c) Minimize pinch hazards. Use the smallest table insert possible with sanding drum. 
d) Avoid kickback. Feed workpiece against rotation of drum.  
e) Avoid entanglement with spinning drum. Do not wear gloves, necktie, or loose clothing. Tie back long hair.
SECTION 1: SAFETY

For Your Own Safety, Read Instruction Manual Before Operating This Machine

The purpose of safety symbols is to attract your attention to possible hazardous conditions. This manual uses a series of symbols and signal words intended to convey the level of importance of the safety messages. The progression of symbols is described below. Remember that safety messages by themselves do not eliminate danger and are not a substitute for proper accident prevention measures. Always use common sense and good judgment.

**DANGER** Indicates an imminently hazardous situation which, if not avoided, WILL result in death or serious injury.

**WARNING** Indicates a potentially hazardous situation which, if not avoided, COULD result in death or serious injury.

**CAUTION** Indicates a potentially hazardous situation which, if not avoided, MAY result in minor or moderate injury. It may also be used to alert against unsafe practices.

**NOTICE** This symbol is used to alert the user to useful information about proper operation of the machine.

Safety Instructions for Machinery

**WARNING**

**OWNER’S MANUAL.** Read and understand this owner's manual BEFORE using machine.

**TRAINED OPERATORS ONLY.** Untrained operators have a higher risk of being hurt or killed. Only allow trained/supervised people to use this machine. When machine is not being used, disconnect power, remove switch keys, or lock-out machine to prevent unauthorized use—especially around children. Make workshop kid proof!

**DANGEROUS ENVIRONMENTS.** Do not use machinery in areas that are wet, cluttered, or have poor lighting. Operating machinery in these areas greatly increases the risk of accidents and injury.

**MENTAL ALERTNESS REQUIRED.** Full mental alertness is required for safe operation of machinery. Never operate under the influence of drugs or alcohol, when tired, or when distracted.

**ELECTRICAL EQUIPMENT INJURY RISKS.** You can be shocked, burned, or killed by touching live electrical components or improperly grounded machinery. To reduce this risk, only allow qualified service personnel to do electrical installation or repair work, and always disconnect power before accessing or exposing electrical equipment.

**DISCONNECT POWER FIRST.** Always disconnect machine from power supply BEFORE making adjustments, changing tooling, or servicing machine. This prevents an injury risk from unintended startup or contact with live electrical components.

**EYE PROTECTION.** Always wear ANSI-approved safety glasses or a face shield when operating or observing machinery to reduce the risk of eye injury or blindness from flying particles. Everyday eyeglasses are NOT approved safety glasses.
WEARING PROPER APPAREL. Do not wear clothing, apparel or jewelry that can become entangled in moving parts. Always tie back or cover long hair. Wear non-slip footwear to reduce risk of slipping and losing control or accidentally contacting cutting tool or moving parts.

HAZARDOUS DUST. Dust created by machinery operations may cause cancer, birth defects, or long-term respiratory damage. Be aware of dust hazards associated with each workpiece material. Always wear a NIOSH-approved respirator to reduce your risk.

HEARING PROTECTION. Always wear hearing protection when operating or observing loud machinery. Extended exposure to this noise without hearing protection can cause permanent hearing loss.

REMOVE ADJUSTING TOOLS. Tools left on machinery can become dangerous projectiles upon startup. Never leave chuck keys, wrenches, or any other tools on machine. Always verify removal before starting!

USE CORRECT TOOL FOR THE JOB. Only use this tool for its intended purpose—do not force it or an attachment to do a job for which it was not designed. Never make unapproved modifications—modifying tool or using it differently than intended may result in malfunction or mechanical failure that can lead to personal injury or death!

AWKWARD POSITIONS. Keep proper footing and balance at all times when operating machine. Do not overreach! Avoid awkward hand positions that make workpiece control difficult or increase the risk of accidental injury.

CHILDREN & BYSTANDERS. Keep children and bystanders at a safe distance from the work area. Stop using machine if they become a distraction.

GUARDS & COVERS. Guards and covers reduce accidental contact with moving parts or flying debris. Make sure they are properly installed, undamaged, and working correctly BEFORE operating machine.

FORCING MACHINERY. Do not force machine. It will do the job safer and better at the rate for which it was designed.

NEVER STAND ON MACHINE. Serious injury may occur if machine is tipped or if the cutting tool is unintentionally contacted.

STABLE MACHINE. Unexpected movement during operation greatly increases risk of injury or loss of control. Before starting, verify machine is stable and mobile base (if used) is locked.

USE RECOMMENDED ACCESSORIES. Consult this owner’s manual or the manufacturer for recommended accessories. Using improper accessories will increase the risk of serious injury.

UNATTENDED OPERATION. To reduce the risk of accidental injury, turn machine OFF and ensure all moving parts completely stop before walking away. Never leave machine running while unattended.

MAINTAIN WITH CARE. Follow all maintenance instructions and lubrication schedules to keep machine in good working condition. A machine that is improperly maintained could malfunction, leading to serious personal injury or death.

DAMAGED PARTS. Regularly inspect machine for damaged, loose, or mis-adjusted parts—or any condition that could affect safe operation. Immediately repair/replace BEFORE operating machine. For your own safety, DO NOT operate machine with damaged parts!

MAINTAIN POWER CORDS. When disconnecting cord-connected machines from power, grab and pull the plug—NOT the cord. Pulling the cord may damage the wires inside. Do not handle cord/plug with wet hands. Avoid cord damage by keeping it away from heated surfaces, high traffic areas, harsh chemicals, and wet/damp locations.

EXPERIENCING DIFFICULTIES. If at any time you experience difficulties performing the intended operation, stop using the machine! Contact our Technical Support at (570) 546-9663.
# Additional Safety for Oscillating Edge Sanders

## WARNING

**WORKPIECE PRESSURE.** Do not jam the workpiece against the sanding surfaces. Firmly grasp the workpiece in both hands and ease it against the belt/spindle using light pressure.

**HAND PLACEMENT.** Do not place hands near, or in contact with, sanding surfaces during operation.

**WORKPIECE HANDLING.** Grip the workpiece with both hands.

**MAINTENANCE.** Perform machine inspections and maintenance promptly as required.

**SANDING BELTS/DRUMS.** Replace sanding belts and drums promptly as needed.

**WORKPIECE QUANTITY.** Never sand more than one piece of stock at a time.

**FOREIGN MATERIAL.** Always inspect stock for nails, staples, knots, and other imperfections that could be dislodged and thrown from the machine during sanding operations.

**DUST COLLECTION.** Never operate the sander without an adequate dust collection system in place and running.

**DIRECTION.** Never sand tapered or pointed stock with the point facing the feed direction.

**POWER DISCONNECT.** Disconnect the machine from the power source before changing the sanding belt or sleeve.

**TEST RUN.** Test run the machine before starting any work.

### WARNING

Like all machinery there is potential danger when operating this machine. Accidents are frequently caused by lack of familiarity or failure to pay attention. Use this machine with respect and caution to decrease the risk of operator injury. If normal safety precautions are overlooked or ignored, serious personal injury may occur.

### CAUTION

No list of safety guidelines can be complete. Every shop environment is different. Always consider safety first, as it applies to your individual working conditions. Use this and other machinery with caution and respect. Failure to do so could result in serious personal injury, damage to equipment, or poor work results.
SECTION 2: POWER SUPPLY

Availability
Before installing the machine, consider the availability and proximity of the required power supply circuit. If an existing circuit does not meet the requirements for this machine, a new circuit must be installed. To minimize the risk of electrocution, fire, or equipment damage, installation work and electrical wiring must be done by an electrician or qualified service personnel in accordance with all applicable codes and standards.

WARNING
Electrocution, fire, shock, or equipment damage may occur if machine is not properly grounded and connected to power supply.

Full-Load Current Rating
The full-load current rating is the amperage a machine draws at 100% of the rated output power. On machines with multiple motors, this is the amperage drawn by the largest motor or sum of all motors and electrical devices that might operate at one time during normal operations.

G0563 Full-Load Current Rating........... 9 Amps
G0564 Full-Load Current Rating........... 11 Amps

The full-load current is not the maximum amount of amps that the machine will draw. If the machine is overloaded, it will draw additional amps beyond the full-load rating.

If the machine is overloaded for a sufficient length of time, damage, overheating, or fire may result—especially if connected to an undersized circuit. To reduce the risk of these hazards, avoid overloading the machine during operation and make sure it is connected to a power supply circuit that meets the specified circuit requirements.

Circuit Information
A power supply circuit includes all electrical equipment between the breaker box or fuse panel in the building and the machine. The power supply circuit used for this machine must be sized to safely handle the full-load current drawn from the machine for an extended period of time. (If this machine is connected to a circuit protected by fuses, use a time delay fuse marked D.)

CAUTION
For your own safety and protection of property, consult an electrician if you are unsure about wiring practices or electrical codes in your area.

Note: Circuit requirements in this manual apply to a dedicated circuit—where only one machine will be running on the circuit at a time. If machine will be connected to a shared circuit where multiple machines may be running at the same time, consult an electrician or qualified service personnel to ensure circuit is properly sized for safe operation.

Circuit Requirements
This machine is prewired to operate on a power supply circuit that has a verified ground and meets the following requirements:

Nominal Voltage ........................................ 240V
Cycle ....................................................... 60 Hz
Phase ........................................... Single-Phase
Power Supply Circuit ......................... 15 Amps
Plug/Receptacle ............................. NEMA 6-15
Grounding Requirements
This machine MUST be grounded. In the event of certain malfunctions or breakdowns, grounding reduces the risk of electric shock by providing a path of least resistance for electric current.

This machine is equipped with a power cord that has an equipment-grounding wire and a grounding plug. Only insert plug into a matching receptacle (outlet) that is properly installed and grounded in accordance with all local codes and ordinances. DO NOT modify the provided plug!

**WARNING**
Serious injury could occur if you connect machine to power before completing setup process. DO NOT connect to power until instructed later in this manual.

Improper connection of the equipment-grounding wire can result in a risk of electric shock. The wire with green insulation (with or without yellow stripes) is the equipment-grounding wire. If repair or replacement of the power cord or plug is necessary, do not connect the equipment-grounding wire to a live (current carrying) terminal.

Check with a qualified electrician or service personnel if you do not understand these grounding requirements, or if you are in doubt about whether the tool is properly grounded. If you ever notice that a cord or plug is damaged or worn, disconnect it from power, and immediately replace it with a new one.

**Extension Cords**
We do not recommend using an extension cord with this machine. If you must use an extension cord, only use it if absolutely necessary and only on a temporary basis.

Extension cords cause voltage drop, which can damage electrical components and shorten motor life. Voltage drop increases as the extension cord size gets longer and the gauge size gets smaller (higher gauge numbers indicate smaller sizes).

Any extension cord used with this machine must be in good condition and contain a ground wire and matching plug/receptacle. Additionally, it must meet the following size requirements:

**Minimum Gauge Size** ....................... 14 AWG
**Maximum Length (Shorter is Better)** ........ 50 ft.
SECTION 3: SET UP

-needed for Setup

The following are needed to complete the setup process, but are not included with your machine:

<table>
<thead>
<tr>
<th>Description</th>
<th>Qty</th>
</tr>
</thead>
<tbody>
<tr>
<td>Phillips Screwdriver #2</td>
<td>1</td>
</tr>
<tr>
<td>Flat Head Screwdriver</td>
<td>1</td>
</tr>
<tr>
<td>Machinist's Square</td>
<td>1</td>
</tr>
<tr>
<td>Hammer</td>
<td>1</td>
</tr>
<tr>
<td>Socket 7/8&quot;</td>
<td>1</td>
</tr>
<tr>
<td>Ratchet w/6&quot; extension</td>
<td>1</td>
</tr>
<tr>
<td>Hex Wrench 4mm</td>
<td>1</td>
</tr>
<tr>
<td>Dust Collector</td>
<td>1</td>
</tr>
<tr>
<td>Dust Hoses</td>
<td>2</td>
</tr>
<tr>
<td>Hose Clamps</td>
<td>2</td>
</tr>
</tbody>
</table>

Unpacking

This machine was carefully packaged for safe transport. When unpacking, separate all enclosed items from packaging materials and inspect them for shipping damage. If items are damaged, please call us immediately at (570) 546-9663.

IMPORTANT: Save all packaging materials until you are completely satisfied with the machine and have resolved any issues between Grizzly or the shipping agent. You MUST have the original packaging to file a freight claim. It is also extremely helpful if you need to return your machine later.

WARNING
SUFFOCATION HAZARD!
Keep children and pets away from plastic bags or packing materials shipped with this machine. Discard immediately.
Inventory

After all the parts have been removed from the packaging, you should have the following items:

Box Contents: (Figure 3)
A. Fence .......................................................... 1
B. Front Dust Port ........................................... 1
C. Spindle Table Assembly ............................. 1
D. Sanding Belt ............................................... 1
E. Rear Dust Port Cover ....................................... 1
F. Rear Dust Port ............................................. 1
G. Table Insert 1½" ........................................... 1
H. Table Insert 2" ............................................ 1
I. Table Insert 3" ............................................ 1
J. Sanding Drum 3" .......................................... 1
K. Sanding Drum 2½" ........................................ 1
L. Sanding Drum 1½" ........................................ 1
M. Spindle .................................................... 1
N. Miter Gauge ................................................ 1
O. Back Stop .................................................. 1
P. Hardware Bag (Not Shown) ......................... 1
   • Lock Handle .................................................. 1
   • Star Knobs 5/16"-18 x 1" ............................... 2
   • Hex Bolts 5/16"-18 x 1" ................................ 2
   • Hex Bolt 5/16"-18 x 1½" ............................... 1
   • Phillips Head Screws 1/4"-20 x 3/8" .............. 4
   • Flat Washers 1/4" ........................................ 4
   • Spindle Washer 5/16" ................................ 1
   • Flat Washers 5/16" ..................................... 4
   • Hinge Pins .................................................. 4
   • Wrench 10 x 12mm, Open-End ...................... 1
   • Hex Wrench 5mm ......................................... 1
   • Hex Wrench 6mm ......................................... 1
   • Rod ........................................................... 1
   • Drive Puller Plate ....................................... 1
   • Cap Screw 5/16"-18 x 1¼" ............................ 1
   • Cap Screws 1/4"-20 x 1½" ............................ 2

In the event that any non-proprietary parts are missing (e.g. a nut or a washer), we would be glad to replace them, or for the sake of expediency, replacements can be obtained at your local hardware store.
The unpainted surfaces of your machine are coated with a heavy-duty rust preventative that prevents corrosion during shipment and storage. This rust preventative works extremely well, but it will take a little time to clean.

Be patient and do a thorough job cleaning your machine. The time you spend doing this now will give you a better appreciation for the proper care of your machine's unpainted surfaces.

There are many ways to remove this rust preventative, but the following steps work well in a wide variety of situations. Always follow the manufacturer's instructions with any cleaning product you use and make sure you work in a well-ventilated area to minimize exposure to toxic fumes.

**Before cleaning, gather the following:**
- Disposable rags
- Cleaner/detergent (WD-40 works well)
- Safety glasses & disposable gloves
- Plastic paint scraper (optional)

**Basic steps for removing rust preventative:**

1. Put on safety glasses.

2. Coat the rust preventative with a liberal amount of cleaner/detergent, then let it soak for 5–10 minutes.

3. Wipe off the surfaces. If your cleaner/detergent is effective, the rust preventative will wipe off easily. If you have a plastic paint scraper, scrape off as much as you can first, then wipe off the rest with the rag.

4. Repeat **Steps 2–3** as necessary until clean, then coat all unpainted surfaces with a quality metal protectant to prevent rust.

---

**WARNING**
Gasoline and petroleum products have low flash points and can explode or cause fire if used to clean machinery. Avoid using these products to clean machinery.

**CAUTION**
Many cleaning solvents are toxic if inhaled. Only work in a well-ventilated area.

**NOTICE**
Avoid chlorine-based solvents, such as acetone or brake parts cleaner, that may damage painted surfaces.

T23692—Orange Power Degreaser
A great product for removing the waxy shipping grease from your machine during clean up.

**Call**
1-800-523-4777
**To Order**
Site Considerations

Weight Load
Refer to the Machine Data Sheet for the weight of your machine. Make sure that the surface upon which the machine is placed will bear the weight of the machine, additional equipment that may be installed on the machine, and the heaviest workpiece that will be used. Additionally, consider the weight of the operator and any dynamic loading that may occur when operating the machine.

Space Allocation
Consider the largest size of workpiece that will be processed through this machine and provide enough space around the machine for adequate operator material handling or the installation of auxiliary equipment. With permanent installations, leave enough space around the machine to open or remove doors/covers as required by the maintenance and service described in this manual. See below for required space allocation.

Physical Environment
The physical environment where the machine is operated is important for safe operation and longevity of machine components. For best results, operate this machine in a dry environment that is free from excessive moisture, hazardous chemicals, airborne abrasives, or extreme conditions. Extreme conditions for this type of machinery are generally those where the ambient temperature range exceeds 41°–104°F; the relative humidity range exceeds 20%–95% (non-condensing); or the environment is subject to vibration, shocks, or bumps.

Electrical Installation
Place this machine near an existing power source. Make sure all power cords are protected from traffic, material handling, moisture, chemicals, or other hazards. Make sure to leave enough space around machine to disconnect power supply or apply a lockout/tagout device, if required.

Lighting
Lighting around the machine must be adequate enough that operations can be performed safely. Shadows, glare, or strobe effects that may distract or impede the operator must be eliminated.

Figure 4. Minimum working clearances.
Hardware Recognition Chart

USE THIS CHART TO MATCH UP HARDWARE DURING THE ASSEMBLY PROCESS.

MEASURE BOLT DIAMETER BY PLACING INSIDE CIRCLE

- 4mm
- 5mm
- 6mm
- 8mm
- 10mm
- 12mm
- 16mm

LINES ARE 1MM APART

LINES ARE 1/8" INCH APART

WASHERS ARE MEASURED BY THE INSIDE DIAMETER

Model G0563/G0564 (Mfd. Since 10/11)
Back Stop

Components and Hardware Needed: Qty
Hex Bolts 5/16"-18 x 1"................................. 2
Flat Washers 5/16" ........................................... 2
Back Stop.................................................. 1

Tools Needed:
Open-End Wrench 10 x 12mm....................... 1

To mount back stop:

1. Place a washer on each hex bolt and thread approximately one turn into holes in platen, as shown in Figure 5.

2. Slide back stop onto hex bolts and tighten, allowing 1/8" clearance from belt to bottom of the back stop, as shown in Figure 6.

Dust Port Cover

Components and Hardware Needed: Qty
Dust Port Cover........................................... 1
Hinge Pins .................................................. 2

Tools Needed:
Hammer...................................................... 1

To mount dust port cover:

1. Align dust port cover hinges with hinges on back of sander.

2. Insert hinge pins through aligned hinges, as shown in Figure 7, and tap with a hammer for full insertion.

3. Latch belt access door to dust port cover.

Figure 5. Back stop bolts.

Figure 6. Back stop installed.

Figure 7. Dust port cover installed.
Dust Ports

Components and Hardware Needed: Qty
Dust Ports................................................................. 2
Phillips Head Screws ¼"-20 x ⅜"............................... 4
Flat Washers ¼".......................................................... 4
Hinge Pins................................................................. 2

Tools Needed:
Phillips Head Screwdriver #2 ................................. 1

To mount dust ports:

1. Align rear dust port holes with tapped holes on back of sander.

2. Insert Phillips head screws and washers through aligned holes and tighten (see Figure 8).

3. Align hinges of front dust port with hinges on front of sander.

4. Mount front dust port using hinge pins and latches in a similar fashion to dust port cover. (Refer to Dust Port Cover on this page.)

Dust Collection

There are two 4" dust collection ports for the sander that should be connected to a dust collector. The port locations are shown in Figure 9.

Components and Hardware Needed: Qty
Dust Collector............................................................. 1
Dust Hoses 4"............................................................ 2
Hose Clamps 4"......................................................... 4

Tools Needed
Phillips Head Screwdriver #2 ................................. 1

To connect your machine to a dust collection system:

1. Use 4" diameter hose and clamps to connect a dust collection system to your dust ports.

Model T10116 (Figure 10) can be purchased separately through our catalog or online for added dust collection when spindle sanding.

Figure 8. Installing dust port.

Figure 9. G0563/G0564 dust ports.

Figure 10. Model T10116 auxiliary dust table.
Test Run

Once assembly is complete, test run the machine to ensure it is properly connected to power and safety components are functioning correctly.

If you find an unusual problem during the test run, immediately stop the machine, disconnect it from power, and fix the problem BEFORE operating the machine again. The Troubleshooting table in the SERVICE section of this manual can help.

---

**WARNING**

Serious injury or death can result from using this machine BEFORE understanding its controls and related safety information. DO NOT operate, or allow others to operate, machine until the information is understood.

---

**WARNING**

DO NOT start machine until all preceding setup instructions have been performed. Operating an improperly set up machine may result in malfunction or unexpected results that can lead to serious injury, death, or machine/property damage.

---

To test run machine:

1. Clear all setup tools away from machine.
2. Connect machine to power supply.
3. Turn machine ON. Verify motor operation, and then turn machine OFF. The motor should run smoothly and without unusual problems or noises.
4. Turn machine ON. Press Emergency Stop Button, shown in Figure 11.

   —If the machine stops, the EMERGENCY STOP button is working properly. Congratulations! The Test Run is complete.

   —If the machine does not stop, immediately disconnect power to the machine. The EMERGENCY STOP button is not working properly. This safety feature must work correctly before proceeding with regular operations. Call Tech Support for help.

---

Figure 11. Emergency stop button.
SECTION 4: OPERATIONS

⚠️ WARNING
Damage to your eyes, lungs, and hearing could result from using this machine without proper protective gear. Always wear safety glasses, a respirator, and hearing protection when operating this machine.

Emergency Stop Button

The Model G0563/G0564 is equipped with an emergency stop button on top of the sander. Should an emergency occur during use of the sander, immediately press the emergency stop button. See Figure 12 for emergency stop button location.

Sanding Belts

There are many types of sanding belts to choose from. We recommend aluminum oxide for general workshop environments. Below is a chart that groups abrasives into different classes and shows which grits fall into each class.

<table>
<thead>
<tr>
<th>Grit</th>
<th>Type</th>
</tr>
</thead>
<tbody>
<tr>
<td>24–36</td>
<td>Very Coarse</td>
</tr>
<tr>
<td>40–60</td>
<td>Coarse</td>
</tr>
<tr>
<td>80–100</td>
<td>Medium</td>
</tr>
<tr>
<td>120–180</td>
<td>Fine</td>
</tr>
<tr>
<td>220–360</td>
<td>Very Fine</td>
</tr>
</tbody>
</table>

The general rule is to sand a workpiece with progressively higher grits. Refer to Accessories on Page 28 for replacement sanding belts.

⚠️ WARNING
Never use the Model G0563/G0564 for applications other than those for which it was made. DO NOT overload the machine or use excess force when sanding. Severe personal injury, damage to the machine, or damage to your workpiece could occur.
**Installing Belt**

**Components and Hardware Needed:**

- **Sanding Belt** .......................................................... 1

**To install belt:**

1. Open belt access door by removing the star knobs and opening all latches.

2. Lift belt tensioning lever, as shown in Figure 13.

**Figure 13. Belt tensioning lever in released position.**

3. Determine belt direction from the arrows on dust port and access door.

4. Match arrows on sander to arrows inside sanding belt. Place and center belt on sanding drums.

5. Tension sanding belt by pushing belt tensioning lever down.

6. Close belt access door, insert the star knobs, and latch levers.

7. Adjust belt tracking as described on Page 19.

---

**Belt Tracking**

After sanding belt has been installed or replaced, or used for a significant amount of time it is necessary to adjust the sanding belt tracking.

**WARNING**

DO NOT attempt to perform any adjustments to the sanding belt while the machine is connected to a power source. Failure to unplug before adjusting the sanding belt could result in serious personal injury.

**Tools Needed:**

- Hex Wrench 12mm .................................................. 1

**To adjust sanding belt tracking:**

1. Turn machine **ON** long enough to observe tracking of the sanding belt, then turn machine **OFF**.

2. If sanding belt does not track on a centered path across the rollers, adjustment is necessary.

3. **Disconnect machine from power source!**

4. Loosen the jam nut shown in Figure 14.

**Figure 14. Check and adjustment nuts.**

---

Model G0563/G0564 (Mfd. Since 10/11)
5. Determine if sanding belt is tracking too high, or too low:
   —If belt tracks above center, turn adjustment nut, shown in Figure 14, counterclockwise.
   —If sanding belt tracks below center, turn adjustment nut clockwise.

6. Tighten jam nut.

7. Connect machine to power and turn ON. Observe belt tracking behavior:
   —If belt is tracking correctly, no further adjustment is necessary.
   —If belt is not tracking correctly, repeat Steps 3–7.

**Table Adjustment**

The table on the oscillating edge sander moves both vertically and horizontally to accommodate various workpieces shapes and thicknesses. Adjust table height periodically to reduce spot wear of your sanding belt.

**To vertically adjust table:**

1. Loosen the lock handles that secure table height position.

2. Turn table height adjustment wheel shown in Figure 16, clockwise to raise table or counterclockwise to lower table.

**Platen Angle Adjustment**

The sanding angle of the oscillating edge sander is variable between 0 and 90 degrees.

**To adjust platen angle:**

1. Loosen angle adjustment lock handle and tilt sander until the pointer is aligned with desired angle, as shown in Figure 15.

2. Tighten angle adjustment lock handle.

**Note:**—Refer to Page 32 to calibrate angle scale.

---

*Figure 15. Adjusted sanding angle.*

*Figure 16. Height adjustment controls.*

Continued on next page
To horizontally adjust table:

1. Move table lock levers to the loose position, as illustrated by labels on machine.

2. Push or pull table until there is a gap of no more than \( \frac{1}{16} \)" from sanding belt, as shown in Figure 17.

3. Move table lock levers to the locked position to secure table position.

---

**Miter Gauge**

The miter gauge needs to be adjusted perpendicular to the face of the belt when it is mounted in the table slot.

To adjust miter gauge:

1. Use a machinist square with one edge against face of miter gauge and the other against belt face, as shown in Figure 18.

2. Loosen lock knob on miter gauge to adjust it flush with edge of the square.

3. Tighten lock knob, and verify the setting. Note—*Sometimes the tightening procedure can affect adjustment.*

4. Loosen the screw that secures the angle pointer and adjust pointer to the 0° mark on scale.

5. Retighten screw that secures the angle pointer.
Sanding Spindle

The Model G0563/G0564 comes with a spindle sanding attachment for sanding curved surfaces. The included sanding drums measure 1½", 2", and 3" in diameter. Be sure to periodically adjust table height to minimize spot wear on the spindle/belt.

Components and Hardware Needed:  

<table>
<thead>
<tr>
<th>Item</th>
<th>Qty</th>
</tr>
</thead>
<tbody>
<tr>
<td>Spindle</td>
<td>1</td>
</tr>
<tr>
<td>Spindle Washer 5/16&quot;</td>
<td>1</td>
</tr>
<tr>
<td>Hex Bolt 5/16&quot;-18 x ½&quot;</td>
<td>1</td>
</tr>
<tr>
<td>Spindle Table Assembly</td>
<td>1</td>
</tr>
<tr>
<td>Lock Handle</td>
<td>1</td>
</tr>
<tr>
<td>Sanding Drum (dia. of choice)</td>
<td>1</td>
</tr>
<tr>
<td>Table Insert (dia. of choice)</td>
<td>1</td>
</tr>
</tbody>
</table>

Tools Needed:  

- Open-End Wrench 10 x 12mm........1
- Hex Wrench 5mm.....................1
- Phillips Head Screwdriver........1
- Rod (included)........................1

To install sanding spindle:

1. Release the belt guard latch, open cover, and latch cover to the belt access door.

2. Remove the three cap screws and false cover from the drum.

3. Line up the screw holes and place the spindle into the drum.

4. Thread cap screws removed in Step 2 into drum and tighten, as shown in Figure 19.

5. Slide sanding drum onto spindle, and insert spindle washer and hex bolt into top of spindle.

6. Insert rod into hole in base of spindle to anchor it, and tighten hex bolt, as shown in Figure 20.

7. Insert spindle table assembly shaft into opening in idler roller bracket (see Figure 21).

8. Thread table lock handle into pre-tapped hole in idler roller bracket. Note—the handle is spring loaded and can be used as a ratchet.

9. Remove 4" table insert by removing three flat head screws in the insert.

10. Replace with table insert that matches sanding drum diameter. Tighten with flat head screws removed in Step 9.
Spindle Table Height

The spindle table on the oscillating edge sander can be moved vertically to accommodate various sanding operations and to decrease spot wear on the sanding drums.

**CAUTION**

**KEEP HANDS CLEAR of all pinch points when adjusting the spindle table.**

To adjust spindle table height:

1. Loosen the adjustment lock handle shown in Figure 22.
2. Raise or lower spindle table to desired height.
3. Tighten the adjustment lock handle.

**Figure 22. Spindle table adjustment lock handle.**

Spindle Sanding

The spindle sander on the Model G0563/G0564 produces a high quality sanding finish on inside contours.

**WARNING**

Do not use the spindle sanding attachment without the spindle table properly installed and the correct table insert for the drum in place. Failure to do so could result in serious personal injury.

To perform spindle sanding operations:

1. Make sure that appropriate spindle and table insert have been installed correctly and that both are secured tightly.
2. Position table in desired location and turn sander ON.
3. While securely holding the workpiece, lightly press it against the spindle and maintain consistent pressure against table, as shown in Figure 23. Use extra caution when sanding end-grain.

**Figure 23. Spindle sanding.**

4. When you have completed your sanding operation, turn sander OFF.
Edge & End Sanding

Proper use of the oscillating edge sander will yield excellent sanding results due to the oscillating movement.

⚠️ CAUTION ⚠️
If you must feed a workpiece into the sanding belt corner first, feed the trailing corner first. Feeding the leading corner first could cause the sanding belt to grab the workpiece and jerk it out of your hands.

To perform an edge or end sanding operation:

1. Start sander by turning sander ON.
2. Support the workpiece against the back stop, and slowly feed workpiece into moving belt, as shown in Figure 24.
3. When you have completed your sanding operation, turn power sander OFF.

Figure 24. Typical edge sanding operation.

Fence

The Model G0563/G0564 comes with a removable fence to assist sanding operations when table is in the horizontal position.

Components and Hardware Needed:

<table>
<thead>
<tr>
<th>Component</th>
<th>Qty</th>
</tr>
</thead>
<tbody>
<tr>
<td>Fence</td>
<td>1</td>
</tr>
<tr>
<td>Star Knob</td>
<td>2</td>
</tr>
<tr>
<td>Flat Washer 5/16&quot;</td>
<td>2</td>
</tr>
</tbody>
</table>

To mount fence:

1. Set fence on table and align the slots with the threaded holes in table.
2. Thread the star knobs and flat washers into the threaded table holes (Figure 25) and tighten.

Figure 25. Fence installed.
SECTION 5: ACCESSORIES

WARNING
Installing unapproved accessories may cause machine to malfunction, resulting in serious personal injury or machine damage. To reduce this risk, only install accessories recommended for this machine by Grizzly.

NOTICE
Refer to our website or latest catalog for additional recommended accessories.

W1304—Pro-Stik Belt Cleaner 1 3/8" x 4 1/4"
W1305—Pro-Stik Belt Cleaner 1 3/8" x 8 1/2"
W1306—Pro-Stik Belt Cleaner 1 1/2" x 1 1/2" x 8 1/2"
W1307—Pro-Stik Belt Cleaner 2" x 2" x 12"
These crepe-rubber belt cleaners quickly remove gum and grit from belts and discs without damage. Just press the cleaning block against your sanding belt or disc until it is clean.

H5445—1 1/2" x 4 1/2", 60 Grit, Hard Sleeve
H5446—1 1/2" x 4 1/2", 80 Grit, Hard Sleeve
H5447—1 1/2" x 4 1/2", 100 Grit, Hard Sleeve
H5448—1 1/2" x 4 1/2", 120 Grit, Hard Sleeve
H5449—1 1/2" x 4 1/2", 150 Grit, Hard Sleeve
H5450—2 x 4 1/2", 60 Grit, Hard Sleeve
H5451—2 x 4 1/2", 80 Grit, Hard Sleeve
H5452—2 x 4 1/2", 100 Grit, Hard Sleeve
H5453—2 x 4 1/2", 120 Grit, Hard Sleeve
H5454—2 x 4 1/2", 150 Grit, Hard Sleeve
H5455—3 x 4 1/2", 60 Grit, Hard Sleeve
H5456—3 x 4 1/2", 80 Grit, Hard Sleeve
H5457—3 x 4 1/2", 100 Grit, Hard Sleeve
H5458—3 x 4 1/2", 120 Grit, Hard Sleeve
H5459—3 x 4 1/2", 150 Grit, Hard Sleeve
H3757—6"W x 108"L, 60 Grit, Sanding Belt
H3758—6"W x 108"L, 80 Grit, Sanding Belt
H3759—6"W x 108"L, 100 Grit, Sanding Belt
H3760—6"W x 108"L, 120 Grit, Sanding Belt
H3761—6"W x 108"L, 150 Grit, Sanding Belt
H6881—6"W x 89"L, 60 Grit, Sanding Belt
H6882—6"W x 89"L, 80 Grit, Sanding Belt
H6883—6"W x 89"L, 100 Grit, Sanding Belt
H6884—6"W x 89"L, 120 Grit, Sanding Belt
H6885—6"W x 89"L, 150 Grit, Sanding Belt
Grizzly Industrial offers a full selection of replacement sanding belts and sleeves for your Model G0563/G0564. Increase the versatility and overall results from your machine by keeping a full range of grits and using the best choice for each application.

D2057A—Heavy-Duty Mobile Base
D2058A—Super Heavy-Duty Mobile Base
The most stable mobile bases on the market with heavy-duty casters arranged on outriggers for low center of gravity. The D2057A has a weight capacity of 700 lbs. and the D2058A handles up to 1,300 lbs.

order online at www.grizzly.com or call 1-800-523-4777
SECTION 6: MAINTENANCE

Lubrication

After operating the Model G0563/G0564 for approximately 500 hours, refill the gearbox with oil.

Tools Needed:
- Wrench 10 x 12mm Open-End .................. 1
- Hex Wrench 5mm .................................. 1
- Grease Gun w/All Purpose Grease ............... 1
- Oil Can w/Light Machine Oil ..................... 1
- SAE 80W Gear Oil .................................. 1

To check and refill gearbox:

1. Place belt sander in the horizontal position.
2. Remove the cap screws on top of the gearbox cover shown in Figure 28.
3. Remove the hex bolts on opposite side of gearbox and remove the gearbox cover.

General

Regular periodic maintenance of your Model G0563/G0564 will ensure optimum performance. Make a habit of inspecting your machine each time you use it. Check for the following conditions and repair or replace when necessary:

1. Loose mounting bolts.
2. Worn switch.
3. Worn or damaged cords and plugs.
4. Damaged or worn sanding belt.
5. Any other condition that could hamper the safe operation of this machine.

WARNING
Always disconnect power to the machine before performing service adjustments. Failure to do this may result in serious personal injury.

WARNING
Keep hair, clothing, and jewelry away from moving parts at all times. Entanglement can result in death, amputation, or severe crushing injuries!

WARNING
Wear safety glasses during the entire maintenance process. Failure to comply may result in serious personal injury.

Figure 28. Gearbox cap screws.
4. Remove the oil fill plug on top of the gearbox, as shown in Figure 29 and fill with SAE 80W gear oil until the level is 1/2" from the top.

5. Re-install gearbox cover with hex bolts and cap screws.

**Rack and Pinion Gear**
The rack and pinion gear that moves the table vertically should be greased well to maintain smooth operation.

**To grease rack and pinion gear:**

1. With table in its lowest position, wipe the rack and pinion with a rag to remove buildup of sawdust and old grease.

2. Apply a coat of all purpose grease to the rack and pinion gears.

**Grease Fittings and Oil Ports**
There are two oil ports shown in Figure 30 and four grease fittings shown in Figure 31. Lubricate these points after approximately 50 hours of use with light machine oil.

All other bearings on the Model G0563/G0564 are sealed and permanently lubricated, so there is no need to lubricate them.
Tables

The tables of the Model G0563/G0564 can be kept rust-free with regular applications of products like G96® Gun Treatment, SLIPIT®, or Boeshield® T-9 (see Accessories on Page 28 for more details).

Spindle Connector

The spindle connector connects the shafts from the motor to the gearbox and is secured by two set screws that need to be tightened every time the gearbox oil is filled (every 500 hours).

Tools Needed:
Hex Wrench 5mm................................. 1
Hex Wrench 4mm.................................... 1
Open End Wrench 10 x 12mm............... 1

To secure spindle connector set screws:
1. Refer to Lubrication Steps 1–3 on Page 29 to remove gearbox cover.
2. Tighten set screws shown in Figure 32.
3. Re-install gearbox cover.

Eccentric

The eccentric on the Model G0563/G0564 is connected to the shaft by a set screw. This set screw needs to be tightened every time the gearbox oil is filled (every 500 hours).

Tools Needed:
Hex Wrench 5mm................................. 1
Hex Wrench 4mm.................................... 1
Open End Wrench 10 x 12mm............... 1

To secure eccentric set screw:
1. Refer to Lubrication Steps 1–3 on Page 29 to remove the gearbox cover.
2. Tighten set screw on the eccentric shown in Figure 33.
3. Re-install gearbox cover.
**SECTION 7: SERVICE**

Review the troubleshooting and procedures in this section if a problem develops with your machine. If you need replacement parts or additional help with a procedure, call our Technical Support. **Note: Please gather the serial number and manufacture date of your machine before calling.**

## Troubleshooting Machine

<table>
<thead>
<tr>
<th>SYMPTOM</th>
<th>POSSIBLE CAUSE</th>
<th>CORRECTIVE ACTION</th>
</tr>
</thead>
<tbody>
<tr>
<td>Motor will not start.</td>
<td>1. Low voltage. 2. Open circuit in motor or loose connections.</td>
<td>1. Check power line for proper voltage. 2. Inspect all lead connections on motor for loose or open connections.</td>
</tr>
<tr>
<td>Motor will not start; fuses or circuit breakers blow.</td>
<td>1. Short circuit in line cord or plug. 2. Short circuit in motor or loose connections. 3. Incorrect fuses or circuit breakers in power line.</td>
<td>1. Inspect cord or plug for damaged insulation and shorted wires. 2. Inspect all connections on motor for loose or shorted terminals or worn insulation. 3. Install correct fuses or circuit breakers.</td>
</tr>
<tr>
<td>Motor overheats.</td>
<td>1. Motor overloaded. 2. Air circulation through the motor restricted.</td>
<td>1. Reduce load on motor. 2. Clean out motor to provide normal air circulation.</td>
</tr>
<tr>
<td>Motor stalls (resulting in blown fuses or tripped circuit).</td>
<td>1. Short circuit in motor or loose connections. 2. Low voltage. 3. Incorrect fuses or circuit breakers in power line. 4. Motor overloaded.</td>
<td>1. Inspect connections on motor for loose or shorted terminals or worn insulation. 2. Correct the low voltage conditions. 3. Install correct fuses or circuit breakers. 4. Reduce load on motor.</td>
</tr>
<tr>
<td>Machine slows when operating.</td>
<td>1. Applying too much pressure to workpiece. 2. Undersized circuit or using ext cord. 3. Run capacitor is a fault.</td>
<td>1. Sand with less pressure—let the movement of the belt do the work. 2. Make sure circuit wires are proper gauge &amp; don’t use extension cords! 3. Replace run capacitor.</td>
</tr>
<tr>
<td>Loud, repetitious noise coming from machine.</td>
<td>1. Main drive roller hex nut is missing or loose. 2. Motor fan is hitting the cover.</td>
<td>1. Inspect keys and setscrews. Replace or tighten if necessary. 2. Tighten fan or shim cover.</td>
</tr>
<tr>
<td>Machine vibrates excessively.</td>
<td>1. Stand not stable on floor. 2. Loose motor mounting. 3. Weak or broken tension spring. 4. Idler roller is too loose. 5. Broken/defective sanding belt.</td>
<td>1. Secure stand to floor, reposition to level surface, or shim stand. 2. Check/tighten motor mounting. 3. Replace spring. 4. Adjust idler roller. 5. Replace sanding belt.</td>
</tr>
</tbody>
</table>

**WARNING**

Disconnect power to the machine when performing any troubleshooting. Failure to do this may result in serious personal injury.
# Troubleshooting Sanding

<table>
<thead>
<tr>
<th>SYMPTOM</th>
<th>POSSIBLE CAUSE</th>
<th>CORRECTIVE ACTION</th>
</tr>
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</table>
| Deep sanding grooves or marks in workpiece. | 1. Sanding belt grit too coarse for the desired finish.  
2. Workpiece is being sanded across the grain.  
3. Too much sanding force on workpiece.  
4. Workpiece held still against the belt. | 1. Use a finer grit sanding belt.  
2. Sand with the grain.  
3. Reduce pressure on workpiece while sanding.  
4. Keep workpiece moving while sanding on the belt. |
| Grains easily rub off the belt. | 1. Sanding belt has been stored in an incorrect environment.  
2. Sanding belt has been folded or smashed. | 1. Store sanding belt away from extremely dry or hot temperatures.  
2. Hang sanding belt or store unfolded and unstacked. |
| Glazed sanding belt. | 1. Sanding wet stock.  
2. Sanding stock with high residue. | 1. Dry stock properly before sanding.  
2. Use different stock. Or, accept the characteristics of the stock and plan on cleaning/ replacing belts frequently. |
| Burn marks on workpiece. | 1. Using too fine of sanding belt grit.  
2. Using too much pressure against belt.  
3. Work held still for too long. | 1. Use a coarser grit sanding belt.  
2. Reduce pressure on workpiece while sanding.  
3. Do not keep workpiece in one place for too long and allow to cool. |
| Sanding belt clogs quickly or burns. | 1. Using too much pressure against belt.  
2. Sanding softwood. | 1. Reduce pressure on workpiece while sanding.  
2. Use different stock. Or, accept the characteristics of the stock and plan on cleaning/ replacing belts frequently with Pro-Stik cleaning pads. |
| Workpiece frequently gets pulled out of your hand. | 1. Not supporting the workpiece against the stop.  
2. Starting the workpiece on a leading corner. | 1. Use back stop to support workpiece.  
2. Start workpiece on a trailing corner. |
| Sanding belt comes off during operation. | 1. Tracking/Oscillation out of adjustment. | 1. Set belt tracking as described in Section: 7 Service Page 32. |

---

**WARNING**

Disconnect power to the machine when performing any troubleshooting. Failure to do this may result in serious personal injury.
About Service

This section is designed to help the operator with adjustments that were made at the factory and that may also need to be made during the life of the machine.

This section is provided for your convenience—it is not a substitute for the Grizzly Service Department. If any adjustments arise that are not described in this manual, then feel free to call the Grizzly Service Department at (570) 546-9663.

Similarly, if you are unsure of how to perform any procedure in this section, the Grizzly Service Department will be happy to guide you through the procedures or help in any other way.

---

Calibrating Angle Gauge

In order to maintain accuracy and precision with the oscillating edge sander, periodically calibrate the angle gauge.

**Tools Needed:**
- Machinist's Square ............................................ 1
- Flat Head Screwdriver ....................................... 1

**To calibrate angle gauge:**

1. Loosen angle adjustment lock handle.
2. Place machinist's square on table and press it against the platen.
3. Adjust platen until it is flush with the machinist's square, as shown in Figure 34.
4. Tighten angle adjustment lock handle.

---

**WARNING**
Always disconnect power to the machine before performing service adjustments. Failure to do this may result in serious personal injury.

**Figure 34.** Aligning table to platen.
5. Loosen angle indicator pin screw, shown in Figure 35, $\frac{1}{2}$ turn.

6. Align angle indicator pin with the 90° mark and tighten angle indicator pin screw.

Figure 35. Angle indicator pin screw.

To remove drive roller:

1. Remove hex nut and lock washer securing drive roller to shaft.

2. Thread the two $\frac{3}{4}$"-20 x 1\(\frac{3}{4}\)" cap screws on the puller four turns into the threaded holes in drive roller.

3. Thread and tighten the $\frac{3}{16}$"-18 x 1\(\frac{1}{4}\)" cap screw on the puller, shown in Figure 36, until drive roller is pulled.

Figure 36. Using the drive roller puller.

4. To re-install, place drive roller on shaft, and thread the lock washer and hex nut onto shaft and tighten securely.

NOTE—Do not hammer drive roller onto shaft or you will cause damage to the shaft.

Removing Drive Roller

The Model G0563/G0564 comes equipped with a puller to remove the drive roller should it become necessary to do so.

Tools Needed:

- Cap Screw $\frac{5}{16}$"-18 x 1\(\frac{1}{4}\)".......................... 1
- Cap Screw $\frac{1}{4}$"-20 x 1\(\frac{3}{4}\)".......................... 2
- Drive Puller Plate................................. 1
- Hex Wrench 5mm................................. 1
- Hex Wrench 6mm................................. 1
- Socket $\frac{7}{8}$"........................................ 1
- Ratchet w/6" extension.......................... 1
SECTION 8: WIRING

These pages are current at the time of printing. However, in the spirit of improvement, we may make changes to the electrical systems of future machines. Compare the manufacture date of your machine to the one stated in this manual, and study this section carefully.

If there are differences between your machine and what is shown in this section, call Technical Support at (570) 546-9663 for assistance BEFORE making any changes to the wiring on your machine. An updated wiring diagram may be available. Note: Please gather the serial number and manufacture date of your machine before calling. This information can be found on the main machine label.

WARNING

Wiring Safety Instructions

SHOCK HAZARD. Working on wiring that is connected to a power source is extremely dangerous. Touching electrified parts will result in personal injury including but not limited to severe burns, electrocution, or death. Disconnect the power from the machine before servicing electrical components!

MODIFICATIONS. Modifying the wiring beyond what is shown in the diagram may lead to unpredictable results, including serious injury or fire. This includes the installation of unapproved aftermarket parts.

WIRE CONNECTIONS. All connections must be tight to prevent wires from loosening during machine operation. Double-check all wires disconnected or connected during any wiring task to ensure tight connections.

CIRCUIT REQUIREMENTS. You MUST follow the requirements at the beginning of this manual when connecting your machine to a power source.

WIRE/COMPONENT DAMAGE. Damaged wires or components increase the risk of serious personal injury, fire, or machine damage. If you notice that any wires or components are damaged while performing a wiring task, replace those wires or components.

MOTOR WIRING. The motor wiring shown in these diagrams is current at the time of printing but may not match your machine. If you find this to be the case, use the wiring diagram inside the motor junction box.

CAPACITORS/INVERTERS. Some capacitors and power inverters store an electrical charge for up to 10 minutes after being disconnected from the power source. To reduce the risk of being shocked, wait at least this long before working on capacitors.

EXPERIENCING DIFFICULTIES. If you are experiencing difficulties understanding the information included in this section, contact our Technical Support at (570) 546-9663.

NOTE

The photos and diagrams included in this section are best viewed in color. You can view these pages in color at www.grizzly.com.

COLOR KEY

BLACK  BLUE  WHITE  BROWN  GREEN  GRAY  RED  ORANGE  YELLOW  GREEN  PURPLE  PINK  LIGHT BLUE  BLUE  WHITE  TURQUOISE

Model G0563/G0564 (Mfd. Since 10/11)
Disconnect power before performing any electrical service. Electricity presents serious shock hazards that will result in severe personal injury and even death!
Disconnect power before performing any electrical service. Electricity presents serious shock hazards that will result in severe personal injury and even death!
G0563 Breakdown

Motor: 2 HP, 220V, Single-Phase
Motor Speed: 1725 RPM
Belt Size: 6" x 89"
Belt Speed: 3150 FPM
Table Size: 26-3/4" x 12"
Table: Precision Ground Cast Iron
Spindle Sizes: 1-1/2", 2", 3" x 4-1/2"
Oscillation Stroke: 3/4"
Dust Port: (2) 4"
Platen Tilt: 0° - 90°
Net Weight: 396 LBS

G0563 Oscillating 6" x 89" Edge Belt & Spindle/Drum Sander ARE 76-376-4

Model G0563/G0564 (Mfd. Since 10/11)
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-42-
G0564 Breakdown

Motor: 2 HP, 220V, Single-Phase
Motor Speed: 1725 RPM
Belt Size: 6" x 89"
Belt Speed: 3150 FPM
Table Size: 26-3/4" x 12"
Table: Precision Ground Cast Iron
Spindle Sizes: 1-1/2", 2", 3" x 4-1/2"
Oscillation Stroke: 3/4"
Dust Port: (2) 4"
Platen Tilt: 0˚ - 90˚
Net Weight: 396 LBS

G0563 Oscillating 6" x 89" Edge Belt & Spindle/Drum Sander Are
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WARRANTY CARD

Name _____________________________________________________________
Street _____________________________________________________________________________
City _______________________ State _________________________ Zip _____________________
Phone # ____________________ Email _________________________________________________
Model # ____________________ Order # _______________________ Serial # __________________

The following information is given on a voluntary basis. It will be used for marketing purposes to help us develop better products and services. Of course, all information is strictly confidential.

1. How did you learn about us?
   ____ Advertisement  ____ Friend  ____ Catalog
   ____ Card Deck  ____ Website  ____ Other:

2. Which of the following magazines do you subscribe to?
   ____ Cabinetmaker & FDM  ____ Popular Science  ____ Wooden Boat
   ____ Family Handyman  ____ Popular Woodworking  ____ Woodshop News
   ____ Hand Loader  ____ Precision Shooter  ____ Woodwork
   ____ Handy  ____ Projects in Metal  ____ Work
   ____ Home Shop Machinist  ____ RC Modeler  ____ Woodworker West
   ____ Journal of Light Cont.  ____ Rifle  ____ Woodworker’s Journal
   ____ Live Steam  ____ Shop Notes  ____ Other:
   ____ Model Airplane News  ____ Shotgun News
   ____ Old House Journal  ____ Today’s Homeowner
   ____ Popular Mechanics  ____ Wood

3. What is your annual household income?
   ____ $20,000-$29,000  ____ $30,000-$39,000  ____ $40,000-$49,000
   ____ $50,000-$59,000  ____ $60,000-$69,000  ____ $70,000+

4. What is your age group?
   ____ 20-29  ____ 30-39  ____ 40-49
   ____ 50-59  ____ 60-69  ____ 70+

5. How long have you been a woodworker/metalworker?
   ____ 0-2 Years  ____ 2-8 Years  ____ 8-20 Years  ____ 20+ Years

6. How many of your machines or tools are Grizzly?
   ____ 0-2  ____ 3-5  ____ 6-9  ____ 10+

7. Do you think your machine represents a good value?  _____Yes  _____No

8. Would you recommend Grizzly Industrial to a friend?  _____Yes  _____No

9. Would you allow us to use your name as a reference for Grizzly customers in your area?
   Note: We never use names more than 3 times.  _____Yes  _____No

10. Comments: ________________________________________________________________
    ___________________________________________________________________________
    ___________________________________________________________________________
    ___________________________________________________________________________
Send a Grizzly Catalog to a friend:

Name___________________________________________
Street___________________________________________
City____________________State______Zip________

TAPE ALONG EDGES--PLEASE DO NOT STAPLE
Grizzly Industrial, Inc. warrants every product it sells for a period of 1 year to the original purchaser from the date of purchase. This warranty does not apply to defects due directly or indirectly to misuse, abuse, negligence, accidents, repairs or alterations or lack of maintenance. This is Grizzly’s sole written warranty and any and all warranties that may be implied by law, including any merchantability or fitness, for any particular purpose, are hereby limited to the duration of this written warranty. We do not warrant or represent that the merchandise complies with the provisions of any law or acts unless the manufacturer so warrants. In no event shall Grizzly's liability under this warranty exceed the purchase price paid for the product and any legal actions brought against Grizzly shall be tried in the State of Washington, County of Whatcom.

We shall in no event be liable for death, injuries to persons or property or for incidental, contingent, special, or consequential damages arising from the use of our products.

To take advantage of this warranty, contact us by mail or phone and give us all the details. We will then issue you a “Return Number,” which must be clearly posted on the outside as well as the inside of the carton. We will not accept any item back without this number. Proof of purchase must accompany the merchandise.

The manufacturers reserve the right to change specifications at any time because they constantly strive to achieve better quality equipment. We make every effort to ensure that our products meet high quality and durability standards and we hope you never need to use this warranty.

Please feel free to write or call us if you have any questions about the machine or the manual.

Thank you again for your business and continued support. We hope to serve you again soon.
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